



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2620
Job Sheet 167494



Part No: D2620

Job Qty: 20 ea

Part Name: Skidtube, 206 Skidtube



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 11/1/17

Job Tracking No:

Due Date: 11/17/17

Created By: Victoria Michaud-Febrille

Type: SOLD

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea		11/16/17	0.00	0.00	Start Up Skidtubes		
100	Skid tubes	20 pcs		11/17/17	0.10	5.26	Skid tubes		J.Y M.G.G. 17-11-06
110	QC	20 pcs		11/17/17	0.00	0.00	QC5		BE 17-11-07
120	Packaging	20 pcs		11/17/17	0.00	0.00	Packaging3		
130	QC21-SA	20 Ea		11/17/17	0.00	0.00	QC21		

Part Op 100 - 1-Bend extrusion as per Dwg D2620 using CNC Bending Machine program 206.A and Folio Ft008 2- Cut Fwd end
Descriptions: of tube as per Dwg D2620
120 - LOCATION : LG002

DAS
21
9-89

NOV 07 2017

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D2600-1-160 141287	20	53	0	0

Part Specifications

Specifications could not be found.

Plex 11/1/17 1:28 PM dart.Michaud-Febrille.Victoria

DART
AEROSPACE

S007246



Skidtube, 206 Skidtube

PART NO:
Revision:
Operation:
Quantity:
Change No:

D2620

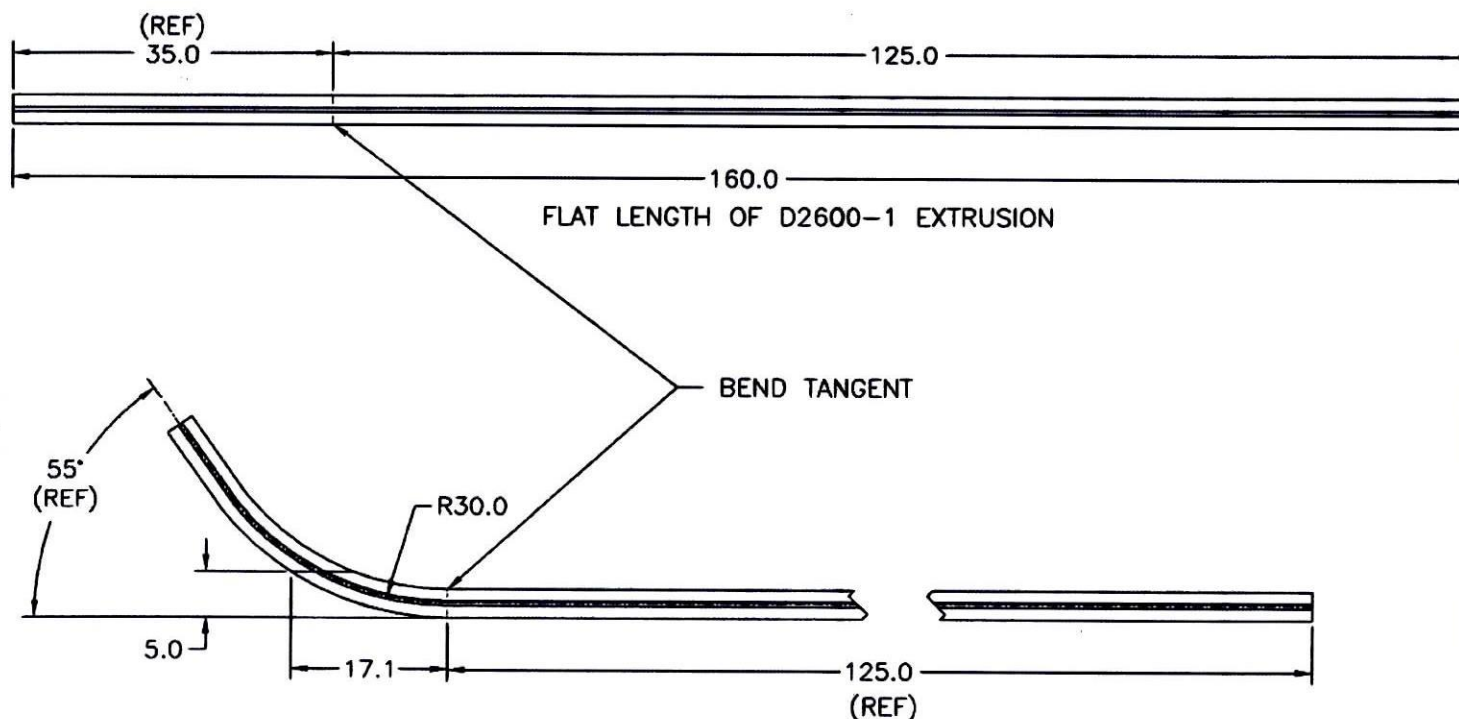
Start up Operation
20

Mfg Date: 11/07/17
Job No: 167494

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SPECIFICATION CONTROL DRAWING

206 SKIDTUBE BENDING



DAMAGE TOLERANCE

1. THERE SHOULD BE NO VISIBLE WRINKLES BELOW 5.0 AFTER BENDING.
2. GOUGES UP TO 0.020 DEEP ARE ACCEPTABLE IN BENT PORTION OF THE TUBE. NO GOUGES ARE ACCEPTABLE IN THE FLAT PORTION OF THE TUBE. DEEPER GOUGES ARE ACCEPTABLE IN THE PORTION OF THE TUBE ABOVE 5.0.
3. TUBE WIDTH SHOULD BE 3.20 ± 0.200 IN THE BEND. TUBE WIDTH SHOULD BE 3.200 ± 0.010 IN THE FLAT PORTION OF THE TUBE.
4. TUBE HEIGHT SHOULD BE 3.15 ± 0.200 IN THE BEND. TUBE HEIGHT SHOULD BE 3.150 ± 0.010 IN THE FLAT PORTION OF THE TUBE.

NOTE: ALL DIMENSIONS ARE IN INCHES

DART



DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CHECKED	APPROVED	FAIRCHILD INTERNATIONAL AIRPORT, WA
DATE	TITLE	REV. B
99.09.10	206 SKIDTUBE BENDING CONTROL	SHEET 1 OF 1
A	97.11.07	NEW ISSUE
B	97.09.10	UPDATE FOR IN-HOUSE BENDING
		SCALE 1:20

RELEASED
44.04.15 DS